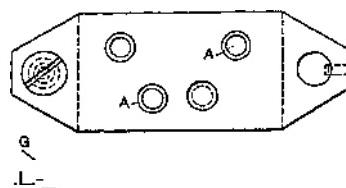
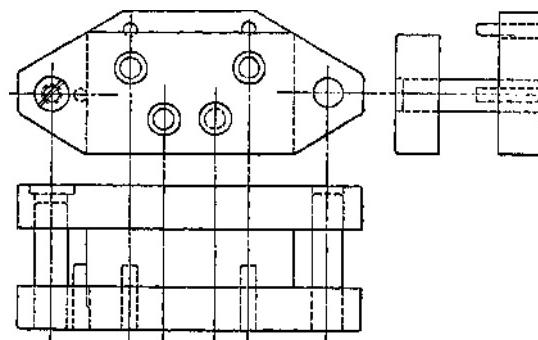


form of a jig that would be used in such a case would be one in which some kind of locating means is employed, as indicated in Fig. 3, where three pins are provided, two along the side of the work and one for the end of the work, against which the work



**Fig. 2. Simple Form of Closed Jig for Drilling Work shown in Fig. 1**

may be pushed prior to the clamping together of the two jig-plates. In this illustration, the jig bushings are not shown in the elevation and end view, in order to avoid confusion of lines. The next improvement to which this jig would be subjected would



**Fig. 3. Locating Pins added to Jig**

be the adding of walls at the end of the jig and the screwing together of the upper and lower plate, the result being a jig as shown in Fig. 4. This design presents a more advanced style of closed jig — a type which could be recommended for manufacturing purposes. While the same fundamental principles are